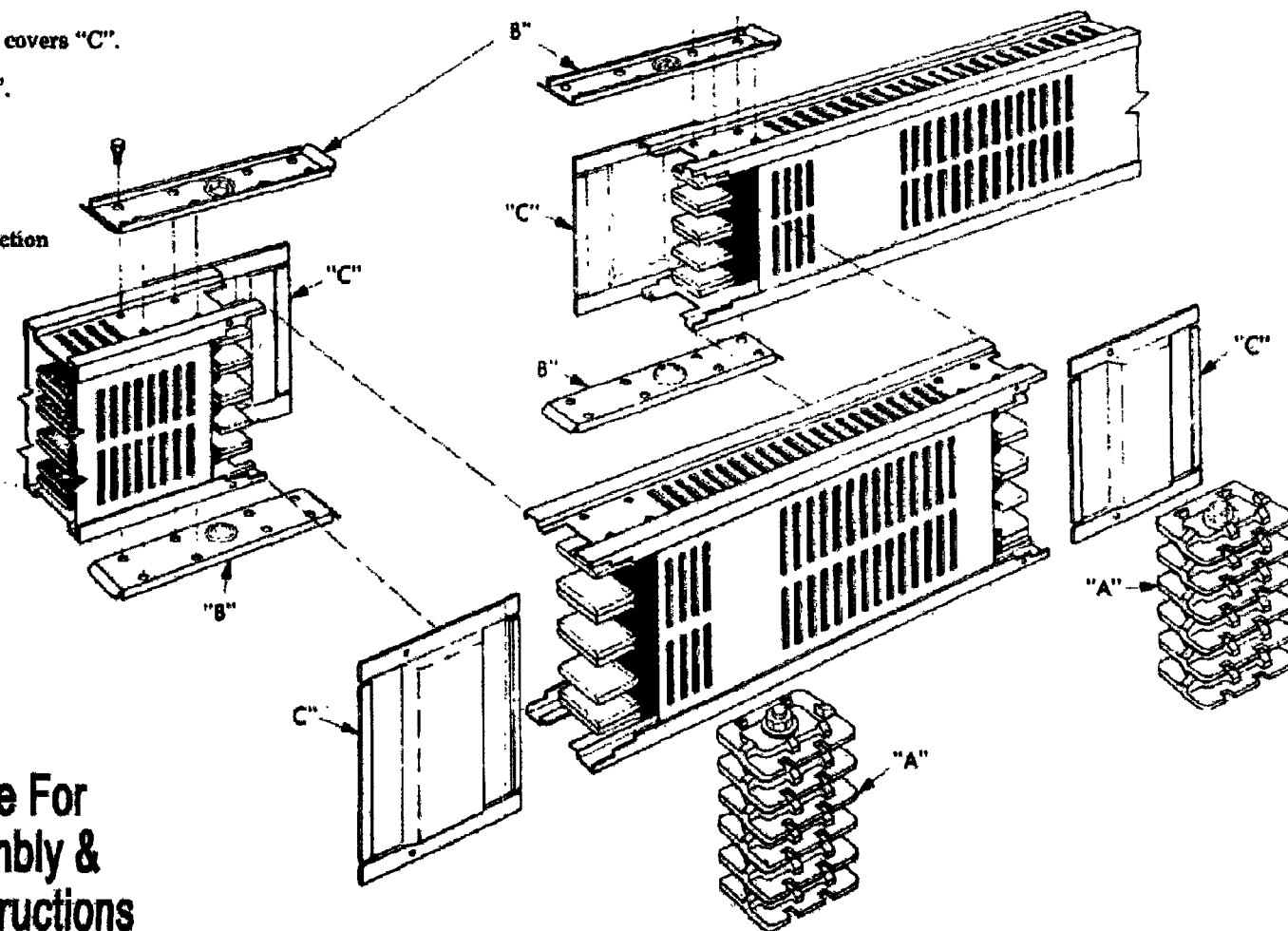
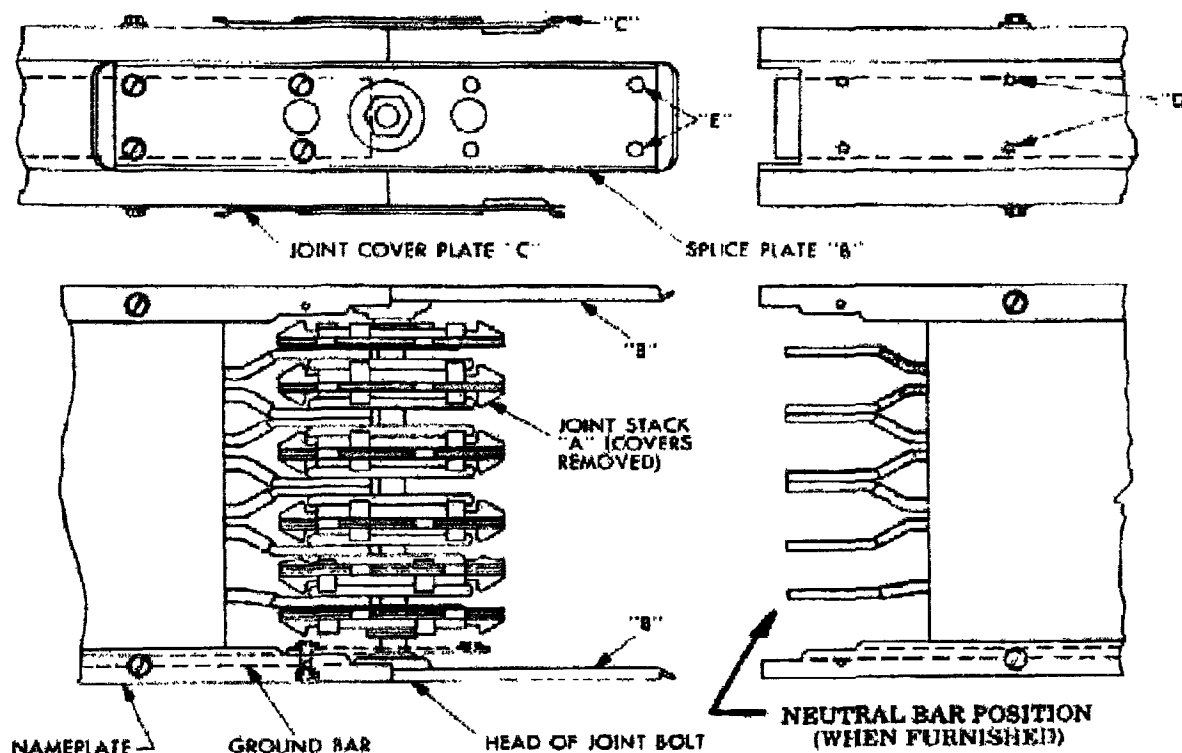


INSTRUCTIONS FOR REMOVING A SECTION FROM BETWEEN TWO ADJACENT SECTIONS

1. Loosen joint bolt — but do not remove.
2. Remove splice plates "B".
3. Remove front set of joint covers "C".
4. Slide out joint stacks "A".
5. Section may be removed horizontally (as shown) or dropped out vertically.
6. To install replacement section reverse the procedure.



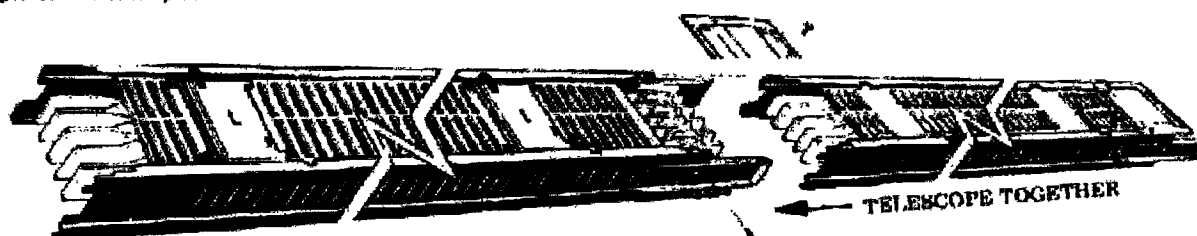
**See Other Side For
Storage, Assembly &
Maintenance Instructions**

STORAGE, ASSEMBLY AND MAINTENANCE INSTRUCTIONS FOR XL-UNIVERSAL BUS DUCT

BEFORE ASSEMBLY: Store both indoor and outdoor duct in a clean, dry place. Protect against physical damage, water or condensate, chemical fumes, concrete, plaster and other contaminants.

All contact surfaces are electroplated and do not require the use of oxide inhibiting compounds. Certain of these greasy compounds can cause deterioration of the bus bar insulation so all types are to be avoided. Do not use steel wool or other abrasives on bus bar contact surfaces.

Joint stack "A" has been factory installed on one end of the duct section or fitting and is held in place by splice plates "B". Splice plates "B" and cover plates "C" need not be removed to complete a joint connection. For convenience, the entire joint stack, splice plates and cover plates can be removed from one end of the duct and reinstalled on the other end.

**TO CONNECT JOINT, PROCEED AS FOLLOWS:**

1. Slide or telescope plain bar end into joint stack until tapped duct holes "D" line up with splice plate holes "E". Loosen joint bolt(s) slightly if joint stack is too tight.
2. Fasten splice plates to duct with 1/4-20 screws provided in attached bag assembly.
3. Using torque wrench, tighten joint bolt heads on joint stack; apply 30 to 35 ft. lbs. torque.
4. If duct is equipped with ground bus, install 3/8-16 bolts and washers (provided for this purpose in the bag assembly) through the holes in the splice plates.

NOTE: Do not mount the nameplate side of the duct toward the ceiling or bus plugs will be upside down.

BEFORE ENERGIZING:

1. Check phase sequence. On 3φ-4W duct the neutral bar is the bar next to the nameplate side of the duct.
2. With load and line ends disconnected, and no over-current devices installed, Megger complete duct run at 1000 volts. Readings should be no less than:

INDOOR: (assuming reasonably clean, dry conditions) Megohms = 300 (divided by) length of run in feet.

OUTDOOR: (assuming conditions of very high humidity) Megohms = 10 (divided by) length of run in feet.

RECOMMENDED MAINTENANCE: Inspect joints periodically; keep free of foreign matter. Initial joint tightening torque is 30 to 35 ft. lbs. Check torque after 6 months; tighten as required. Re-check torque at least once per year thereafter.

SIEMENS
Spartanburg, SC

PC NO 105225 (6/83)

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